



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-5

Job Sheet 180485



Part No: D3065-5

Job Qty: 80 ea

Part Name: Step Leg



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 7/31/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM
IPP Rev:E Now manufactured with 6061-T6 06-05-25 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	80 Ea	7/31/18	7/31/18	0.00	0.00	Start Up Waterjet		SC 18/07/21
100	Waterjet	80 pcs	7/31/18	7/31/18	0.02	7.37	Waterjet1		SC 18/07/21
120	QC	80 pcs	7/31/18	7/31/18	0.00	0.00	QC8		38
130	HandFinish	80 pcs	7/31/18	7/31/18	0.00	1.81	HandFinish1		SA 18-07-24
140	QC	80 pcs	7/31/18	7/31/18	0.00	0.00	QC7-1		38
150	Packaging	80 pcs	7/31/18	7/31/18	0.00	0.00	Packaging3		5-89
160	QC21-SA	80 Ea	7/31/18	7/31/18	0.00	0.00	QC21		JUL 31 2018

Part Op 100 - 1-Cut as per Dwg
Descriptions: 150 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	66 sf (.825 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6S.080	66	251	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Log	16.458inches $\pm$ 0.010	16.468 16.448	16,460	
2	Step Log	15.750inches $\pm$ 0.005	15.755 15.745	15,752	
3	Step Log	2.250inches $\pm$ 0.005	2.255 2.245	2,253	
4	Step Log	3.460inches $\pm$ 0.005	3.465 3.455	3,462	
5	Step Log	0.865inches $\pm$ 0.005	0.870 0.860	0,863	
6	Step Log	6.020inches $\pm$ 0.005	6.025 6.015	6,018	

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Dart Aerospace Ltd. 1270 Abenden Street Windsor, ON K6A 1K7 TEL: 513 632-5200 Email: sales@dartaero.com www.dartaero.com Date: 07/23/18 Barcode Container No: S094898 Part: D3065 - 5 Job No: 180485 Serial No/Batch: S094898 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Crimp/Kink/Ripple/wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Inspection ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : _____							

7	Step Log	1.205inches ± 0.005	1.210 1.200	1,207
8	Step Log	3.484inches ± 0.005	3.489 3.479	3,486
9	Step Log	0.871inches ± 0.005	0.876 0.866	0,873
10	Step Log	8.325inches ± 0.010	8.335 8.315	8,328
11	Step Log	0.551inches ± 0.010	0.561 0.541	0,555
12	Step Log	0.213inches + 0.005 - 0.000	0.218 0.213	0,214
13	Step Log	0.128inches + 0.005 - 0.000	0.133 0.128	0,130

Plex 7/6/18 1:36 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								